

# Work Order ID 74789

**\*74789\***

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October 6, 2011 1:37:50 PM

Item ID: D3562-042

Accept:

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Step Assembly, RH

Start Date: 10/06/11 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: M.L.J.

Date: 11/10/06 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3562	Rev E

100	Large Fab	0.00							
<b>*100*</b>									
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622 extrusion as per Dwg D3562 2-Deburr and bevel ends for welding								

11.11.17 4 φ

110	QC6- Inspect dimensions to drawing	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

Swluliz

(40)

120	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*120*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

11.11.17 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 74789

**\*74789\***

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Item ID: D3562-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Assembly, RH  
 Start Date: 10/06/11 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 10/17/11 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<u>N</u>	<u>BR</u>	<u>11-11-18</u>	
140 <b>*140*</b> Small Fab Small Fab Small Fab	Small Fab  Memo 1- Drill Rivet holes as per dwg D3562. Touch up alodine 2- Rivet legs using Magnabond as per dwg D3562. *****Ensure to wipe off any excess magnabond ***** A/R Magnabond 6398 Batch: <u>117870</u>	0.00  0.00				<u>4</u>	<u>0</u>		<u>11-11-21</u>
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				<u>*4</u>			<u>042</u>

*Sutley*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**Reference:**

Stop \*NR2\*

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.  
A/RAluminum Rod 114514  
2-Grind end cap welds flush as per Dwg D3562

## Quality Control

## Quality Control

x4 LM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 74789

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**\*74789\***

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Item ID: D3562-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Assembly, RH  
 Start Date: 10/06/11 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 10/17/11 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	Chemical Conversion Coat per QSI005 4.1	0.00							
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**\*190\***

HandFinish

Hand Finishing

Memo

0.00

4X Ø M-11/11/25  
RH

200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

**\*200\***

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:15  
320°F  
11:45

0.00

4X Ø M-11/11/28  
RH

210	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
-----	---------------------------------------	------	--	--	--	--	--	--	--

**\*210\***

HandFinish

Hand Finishing

Memo

0.00

4 BR 11-11-28

m 118439

118988

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**\*74789\***

October 6, 2011 1:37:50 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**Customer:**

**\*4\***

**\*4\***

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

0.00

**\*220\***

QC

## Quality Control

## Memo

0.00

4RM of 11/12/29  
counted & measured.

\*230\*

### Packaging

## Packaging

## Memo

0.00

Identify as per dwg & Stock Location: C-A  
w/o 7478

**Memo**

**\*240\***

QC

## Quality Control

## Memo

0.00

QC21- Final Inspection - Work Order Release

11/12/07 (4)

11/2/8

ME  
11-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 74789

**\*74789\***

Parent Item: D3562-042

**\*D3562-042\***

Parent Item Name: Step Assembly, RH

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM  
 IPP rev B ECN 987 07.10.09 EC verified by: DD  
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC  
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2622-120C

Manufactured

No

100

Each

120.2000

1

4

**\*D2622-120C\***

Step Extrusion

\*\*

11.11.17

Location

Loc Qty

Loc Code

HALL

110.5

64409

6

68293

0.5

72131

104

WA

9.7

46910

2

66970

7.7

D2734

Manufactured

No

140

Each

96.0000

2

8

**\*D2734\***

Step End Plate

\*\*

11.11.23

Location

Loc Qty

Loc Code

WA

96

73196

36

73416

60

D3560-042

Manufactured

No

140

Each

0.0000

1

4

**\*D3560-042\***

Arm Weldment

\*\*

374802 \*4

11.11.18

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 74789

**\*74789\***

Parent Item: D3562-042

**\*D3562-042\***

Parent Item Name: Step Assembly, RH

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

D3560-044

Manufactured No

140

Each

5.0000

1

4

**\*D3560-044\***

Arm Weldment

\*\*

*11.11.18*

Location

Loc Qty

Loc Code

WA

5

69617

1

71950

4

MS20600-AD4W5

Purchased

No

160

Each

743.0000

32

128

**\*MS20600-AD4W5\***

Blind Rivet

\*\*

*11.11.19*

Location

Loc Qty

Loc Code

ST321

737

114382

173

117505

200

118384

364

WA018

6

111477

6

*118*  
*10*

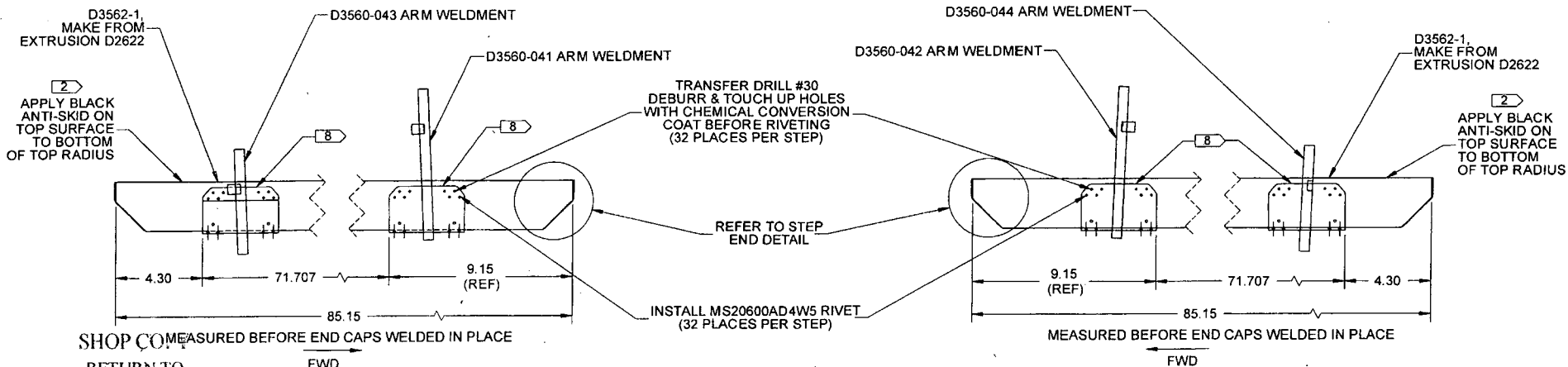
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34785 M.C.J  
11/10/06

#### D3562-041 LH STEP ASSEMBLY

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:
  - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
  - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
  - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.79 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

#### D3562-042 RH STEP ASSEMBLY

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808. REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	9P		
DRAWN	EL		
CHECKED	LE		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.11		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3562** REV. E  
TITLE **STEP ASSEMBLY** SCALE 1:5  
SHEET 1 OF 1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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